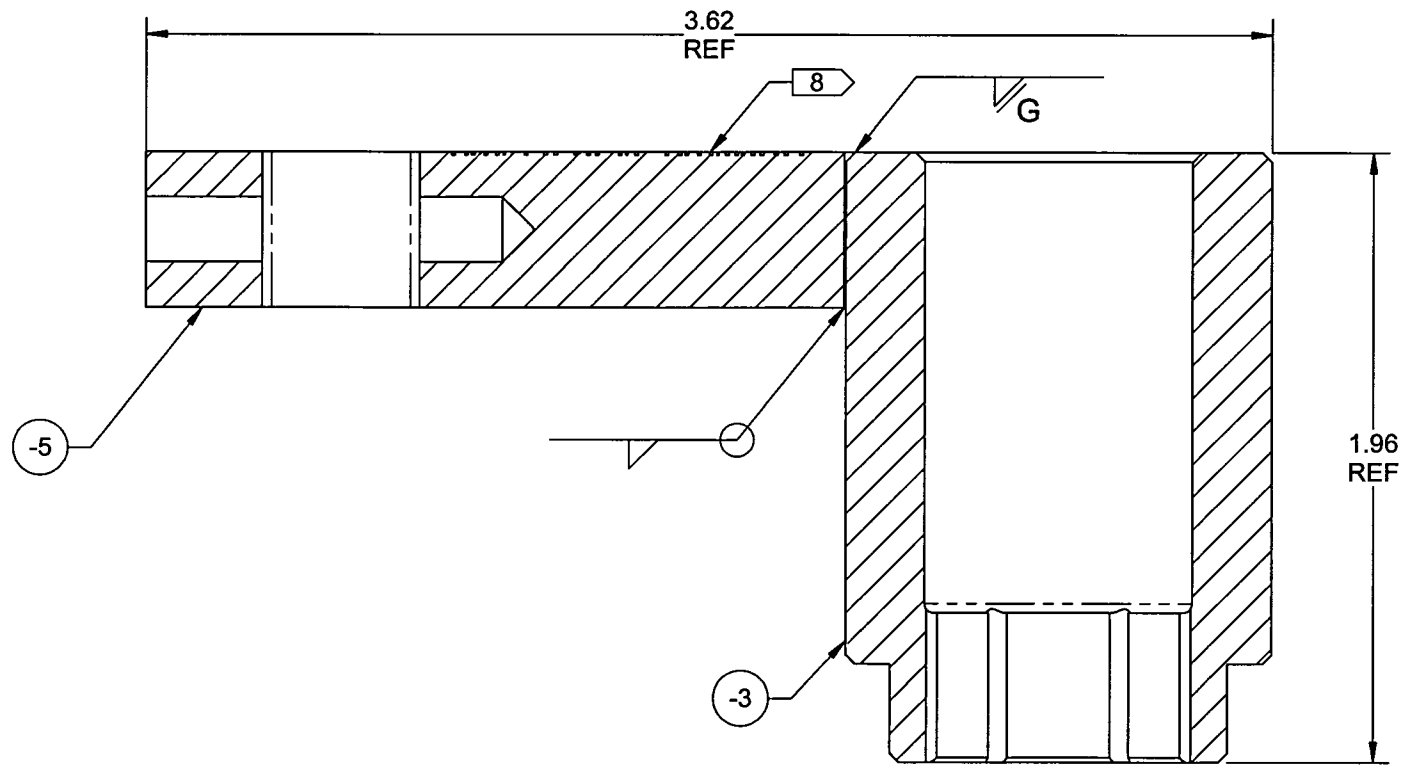


RBW109-3130-83-109 TOOL ASSEMBLY

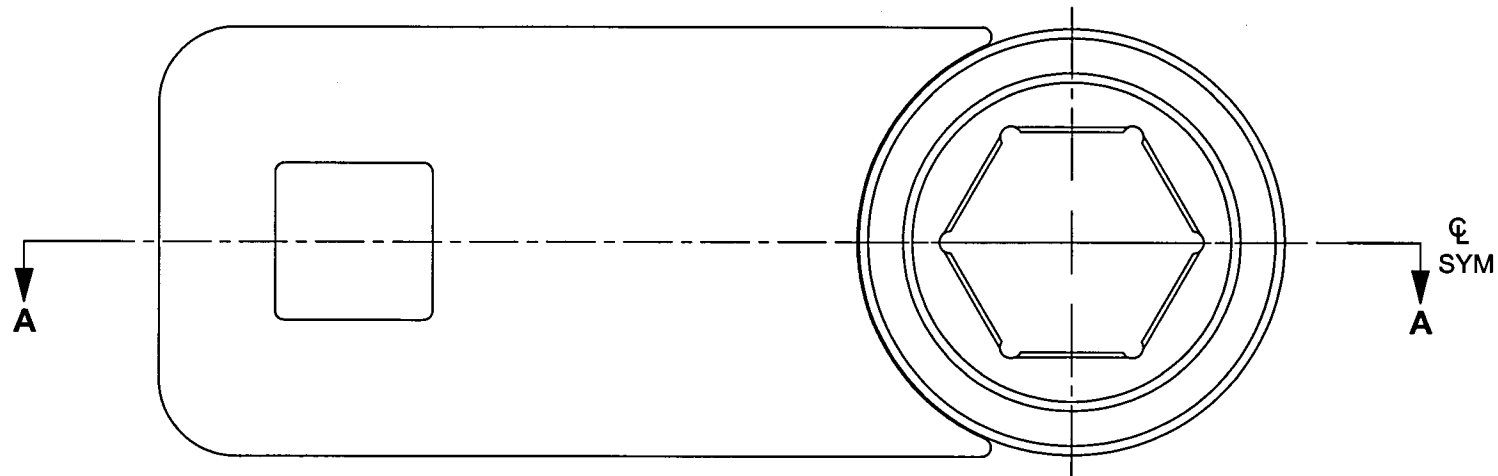
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

A	DIMENSION R.06 CHANGED FOR 0.070" DIA HOLES, MATERIAL 4140 Q&T CHANGED FOR 4140/4142, CMF .03 x 45° ON HEX CHANGED FOR .02 x 45°, REVISION ADDED, TEMPLATE UPDATED,MADE IN USA & S/N REMOVED FROM ENGRAVING, TEMPLATE UPDATED, SYMBOL CL SYM ADDED, CORRECTED T/N WAS -111 IS -109		18-515	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM 03/01/2018			
CHECKED	ML 04/14/2018	TOOL PART #	REV. A	
MFG. APPR.	DD 04/16/2018	RBW109-3130-83-109	SHEET 1 OF 4	
APPROVED	ML 04/16/2018	TITLE	SCALE	
DATE 4/16/2018		REACTOR ASSEMBLY	NTS	
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ITEM #	QTY	PART #	PART TITLE
-3	1	RBW109-3130-83-109-3	WRENCH
-5	1	RBW109-3130-83-109-5	ARM



SECTION A-A



RBW109-3130-83-109-1 WELDMENT

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) ENSURE PART NUMBER IS ON THIS FACE BEFORE WELDING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/01/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/14/2018	TOOL PART #	REV. A
MFG. APPR.	DD 04/16/2018	RBW109-3130-83-109	SHEET 2 OF 4
APPROVED	ML 04/16/2018	TITLE	SCALE
DATE 4/16/2018		REACTOR ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

D

C

B

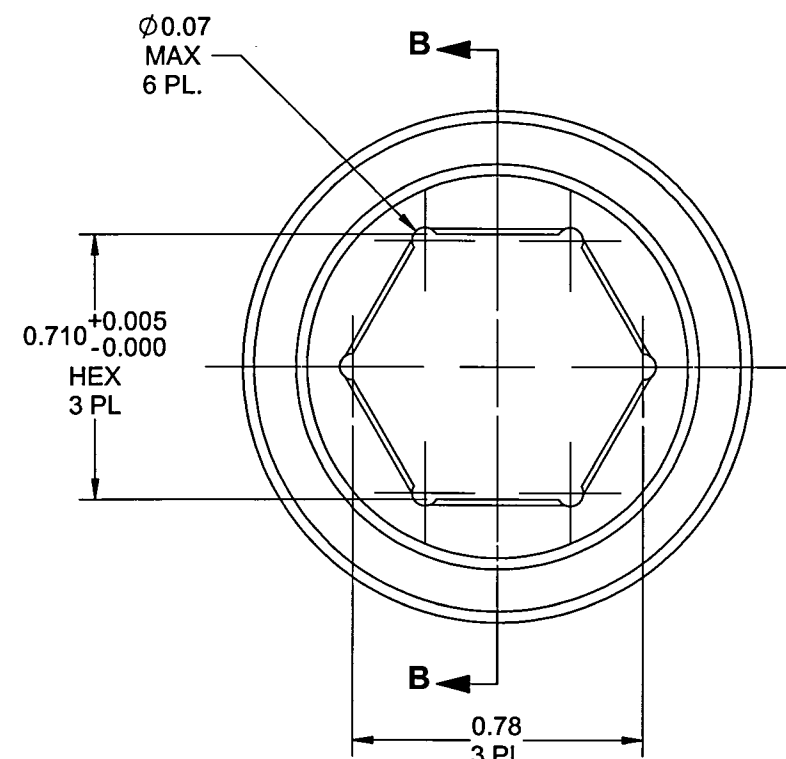
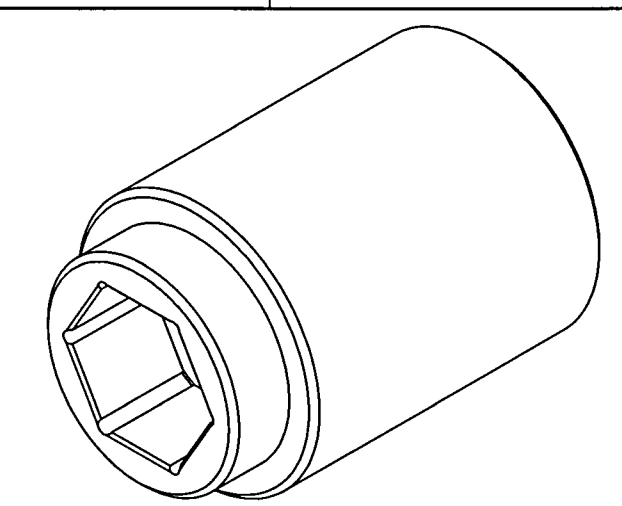
A

D

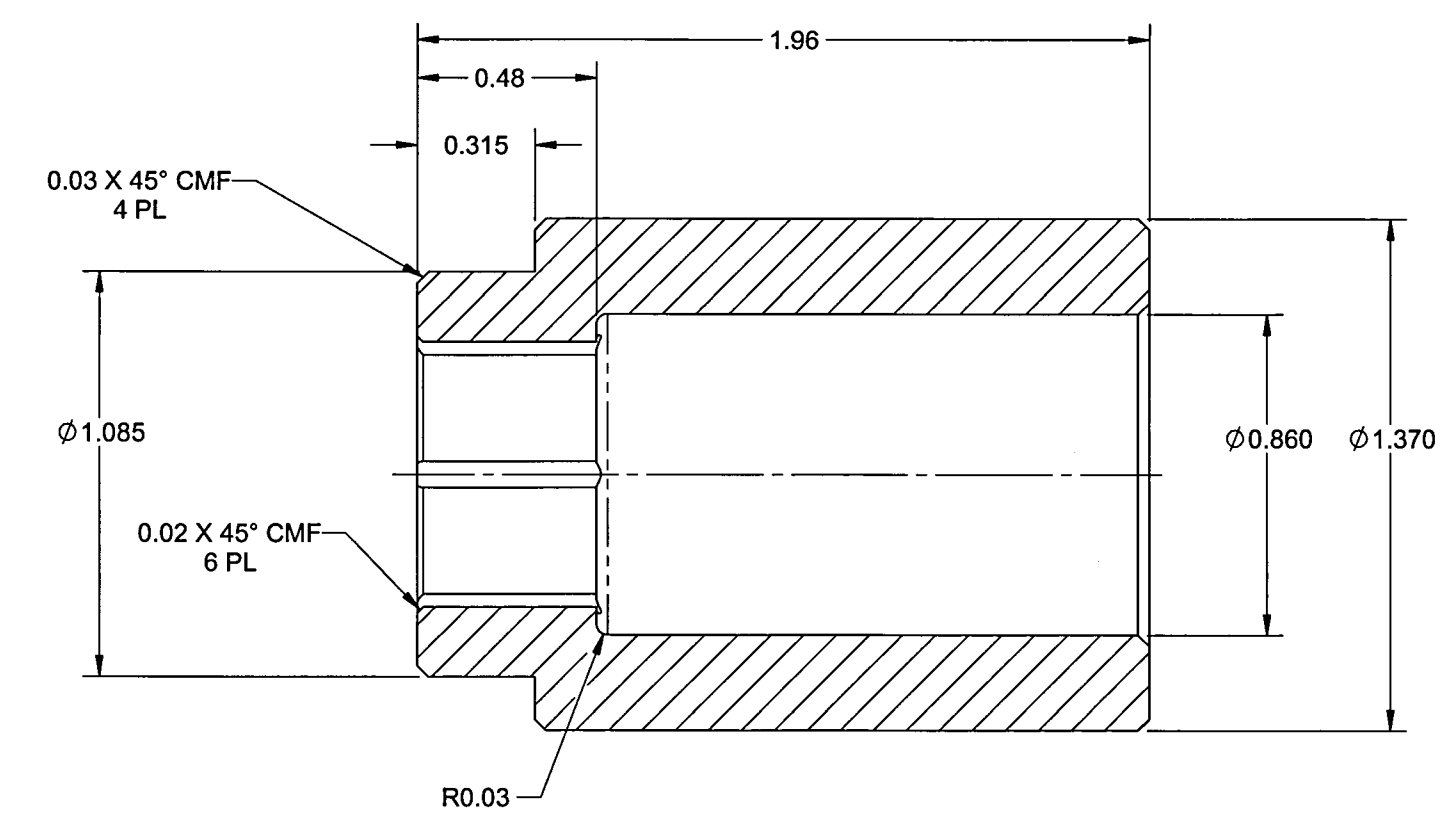
C

B

A



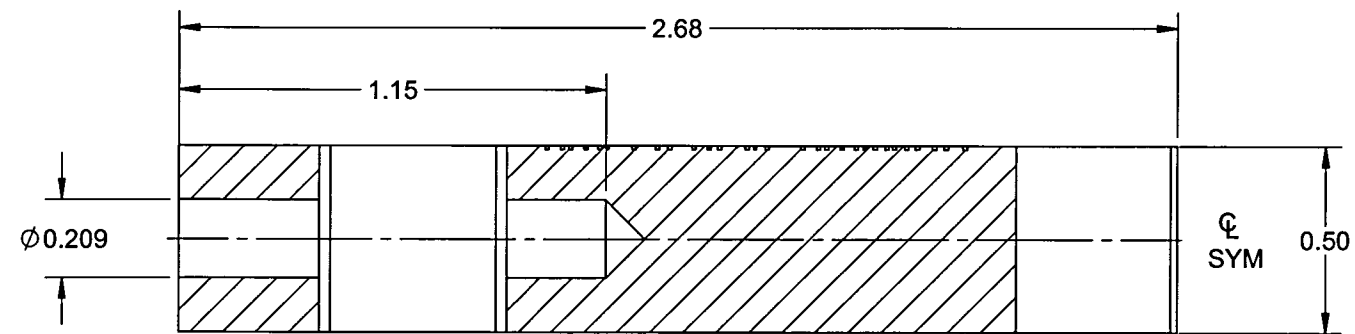
RBW109-3130-83-109-3 WRENCH



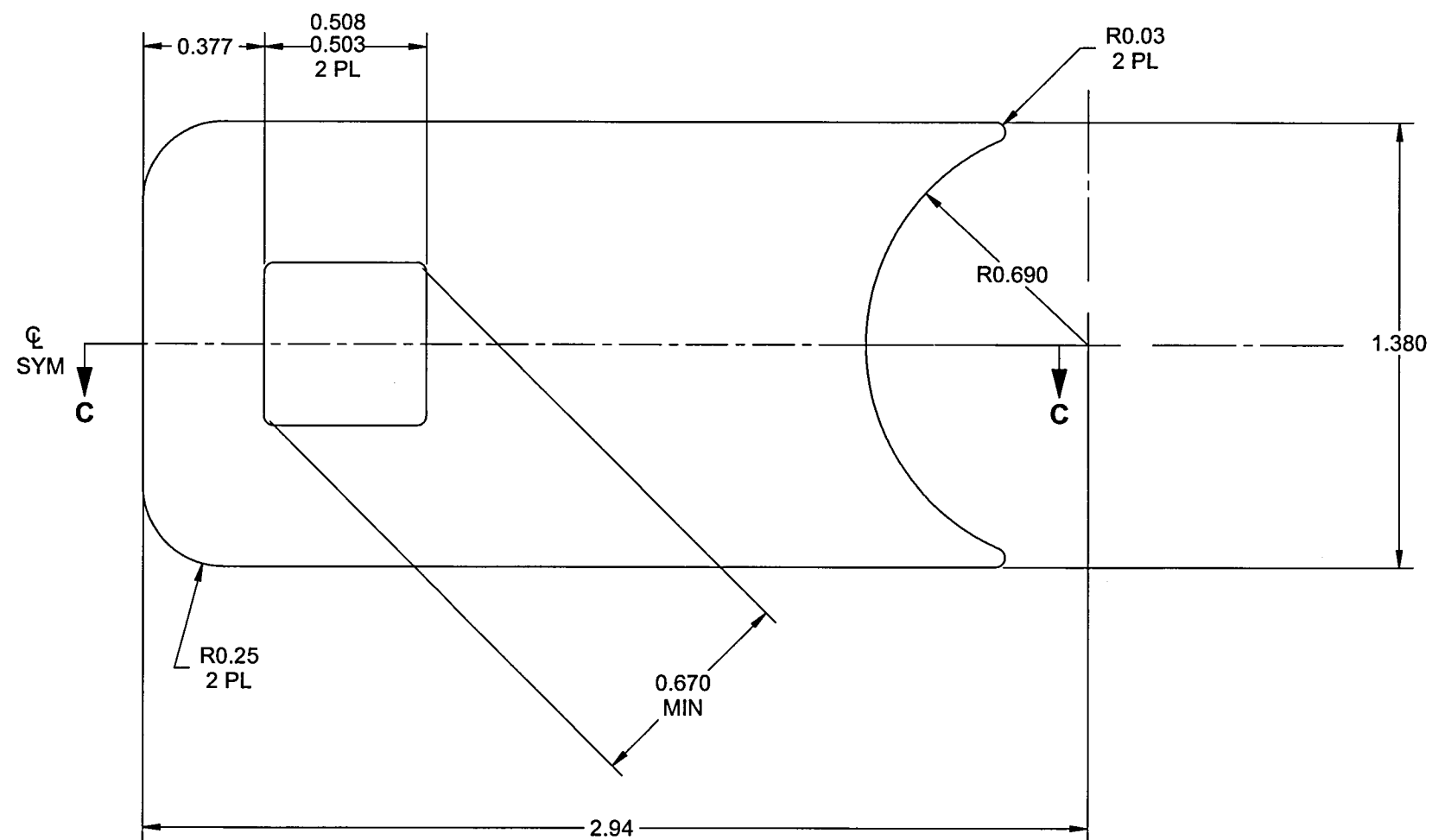
SECTION B-B

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

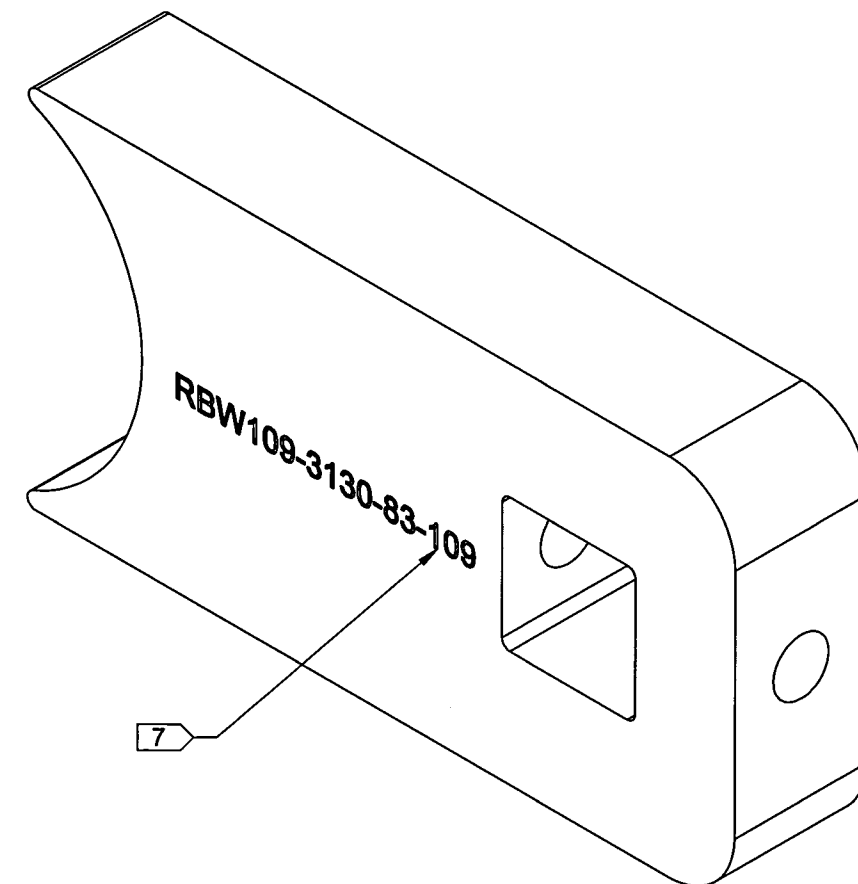
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM 03/01/2018		
CHECKED	ML 04/14/2018	TOOL PART #	REV. A
MFG. APPR.	DD 04/16/2018	RBW109-3130-83-109	SHEET 3 OF 4
APPROVED	ML 04/16/2018	TITLE	SCALE
DATE 4/16/2018		REACTOR ASSEMBLY	NTS
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SECTION C-C



RBW109-3130-83-109-5 ARM



- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/01/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/14/2018	TOOL PART #	REV. A
MFG. APPR.	DD 04/16/2018	RBW109-3130-83-109	SHEET 4 OF 4
APPROVED	ML 04/16/2018	TITLE	SCALE
DATE 4/16/2018		REACTOR ASSEMBLY	NTS
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